

WORK ORDER 2008-19

Date opened: 5 June 2008

Project: High Mounted Quick Release Cargo Basket Assembly
Type: Bell 206L Series, 407Batch Quantity: 2 Complete Basket Assemblies (76610-01)
All with Auxiliary Latch Installation (70403)Approval: SH00-48
Drawing List: DCL766-2

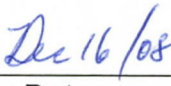
Fabrication and Assembly Drawing(s)	Description
76610, Rev. 0	Basket Ass'y
76611, Rev. 0	Basket Body Ass'y
60632, Rev. 0	Basket Lid Ass'y
36255, Rev. 1	Handle Installation
36261, Rev. 1	Handle Bar Ass'y
36262, Rev. 1	Handle Bracket Ass'y
70403, Rev. 0	Auxiliary Latch Installation

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:



Project is on Approval Limitation Record:	Y ✓
Document Control List revision level matches (or exceeds) STC:	Y ✓
Drawings revision levels match Document Control List:	Y ✓
Purchase order or Work order source is recorded for each part/ass'y:	Y ✓
Tests and inspections specifically called out on drawings are complete:	Y ✓
Release tags associated with all fabricated parts are attached:	Y ✓
All mounting hardware and supplies are included:	Y ✓

List all non-conformities raised: _____


Inspector Signature:
Date:

Drawing: **76610** Revision **0**
 Assembly: **76610-01** **Cargo Basket Ass'y (Quick-Release, High Mounted)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	76610-01	Cargo Basket Assembly			
1	76611-01	Basket Body Assembly	Below		
1	60632-01	Basket Lid Assembly	Below		
1	36255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	7005	
1	MS20001P4	Piano Hinge		8024	
1	76625-01	Placard	0.063" Sheet, 6061-T6 Aluminum	960708	
3	49205-14	Bumper	Argus Industries Bumper	8071	
A/R	CR3213-4-02	Cherry Rivet		8034	
4	40088-14	Fitting	Ancra	8032	
4	AN960-616	Washer		6016	
1	AN3-15A	Bolt		6016	
1	AN3-17A	Bolt		6066	
4	AN960-10	Washer		6043	
2	AN970-3	Washer		5026	
2	MS21044N3	Nut		6016	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-4-02 Rivets		
Final Inspection	Drawing 76610			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **76611** Revision 1
 Assembly: **76611-01** **Basket Body Ass'y (High Mounted Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	76611-01	Basket Body Assembly			
1	76621-01	End Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
4	76623-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
1	76622-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
2	60640-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
5	60643-01	Spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
1	36262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	951108	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 76611			
Final Inspection	Drawing 76611			

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Drawing: **60632** Revision **0**
 Assembly: **60632-01** **Basket Lid Ass'y (High Mounted Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	60632-01	Basket Lid Assembly			
2	60640-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
4	49213-01	Lid Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	951108	
1	36262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9516042	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	
6	60649-01	Step Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
A/R	60632-10	Tread Plate	3003 Aluminum, 0.063 tread sheet	7058	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		4L
Powder Coat	Drawing 60632			gc.
Final Inspection	Drawing 60632			gc.

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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	36255-01	Handle Installation			
1	36261-01	Handle Bar Assembly	Below		
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	7004	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	6068	
2	AN3-14A	Bolt		6071	
4	AN960-10	Washer		6043	
2	MS21044N3	Nut		6016	


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 36255			

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Drawing: 36261 Revision 1
Assembly: 36261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	8066	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	7006	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	2005	
2	MS20615-4M3	Rivet		7039	


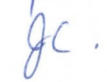
Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36261			

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Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	36261-01	Handle Bracket Assembly			
1	36272-01	Basket Bracket	321 Stainless, 0.050 Sheet	3021	
2	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	3021	
2	36275-02	Support	304 Stainless, 5/16" Rod	6003	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36262			

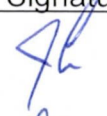

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Drawing: **70403** Revision **0**
 Assembly: **70403-01** **Auxiliary Latch Modification**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	70403-01	Auxiliary Latch Modification			
2	60650-04	Tab	321 Stainless Steel, 0.032 Sheet	3021	
2	60650-05	Insert	1018 Steel, 0.375 Rod	951108	
1	60650-06	Bushing	Brass, 0.25 Rod	7047	
1	0115-306	Latch Cord	Arctic Cat	8046	
1	0115-307	Latch Cup	Arctic Cat	8046	
1	AN3-10A	Bolt		6071	
2	AN960-10	Washer		6016	
1	MS21044N3	Nut		6016	
2		#8-32 Screw	Stainless steel, commercial		

Note: Remainder of assembly listed on drawing 76611 and 60632

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70403			

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CC 1754

AERO Design Ltd.
2013 – 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket (High Mounted) Part #: 76610-01

Approval #: SH00-48 Serial #: 76601-04

WO #: 2008-19 Quantity: 1

Eligibility: Bell 206L Series / 407 Work Status: Manufactured

Remarks: Lid Step and Auxiliary Latch IAW DCL704

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Dec 16/08
Date

Jeff Chik.
Inspector's Signature

CC H201
AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

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Oct 7/08
Date

Jeff Clarke
Inspector's Signature